

Date: Wednesday, 5/23/2007 3:45:37 PM
 User: Kim Johnston

Process Sheet

| | |
|--|------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : DOUBLER |
| Job Number : 32514 | |
| Estimate Number : 10892 | |
| P.O. Number : <u>N/A</u> | Part Number : D32861 |
| This Issue : 5/23/2007 S.O. No. : <u>N/A</u> | Drawing Number : D3286 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <u>N/A</u> Type : SMALL /MED FAB | Drawing Revision : A |
| Previous Run : 29090 | Material : <u>N/A</u> |
| Written By : <u>[Signature]</u> | Due Date : 5/30/2007 |
| Checked & Approved By : <u>[Signature]</u> | Qty: <u>34</u> Um: Each |
| Comment : Est A 04.07.14 New issue KJ/JLM | |
| Est Rev:B Now on Waterjet 06-06-16 JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------|--------------------|
| 1.0 | M304S11GA | 304/316 .125 Sheet |
|-----|-----------|--------------------|



Comment: Qty.: 0.0786 sf(s)/Unit Total : 2.3594 sf(s)

304/316 .125 Sheet

Batch: M102817

SAD 07/06/11

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3286

Dwg Rev: A

Prog Rev: A

SAD 07/06/11

2-Deburr if necessary

mf 07-06-25

34

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/06/11

34

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

En 07/06/11

(x34)

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE

Form as per Dwg D3286

SB 07/07/11

(x34)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:45:37 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 32514

Part Number: D32861

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



checked w/
Pence P200 tabs

Comment: INSPECT WORK TO CURRENT STEP

EP 07/07/20

(X34)
could

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/07/23 (34)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(31)

Comment: FINAL INSPECTION/W/O RELEASE

10/10/23

Job Completion



U 07.07.23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

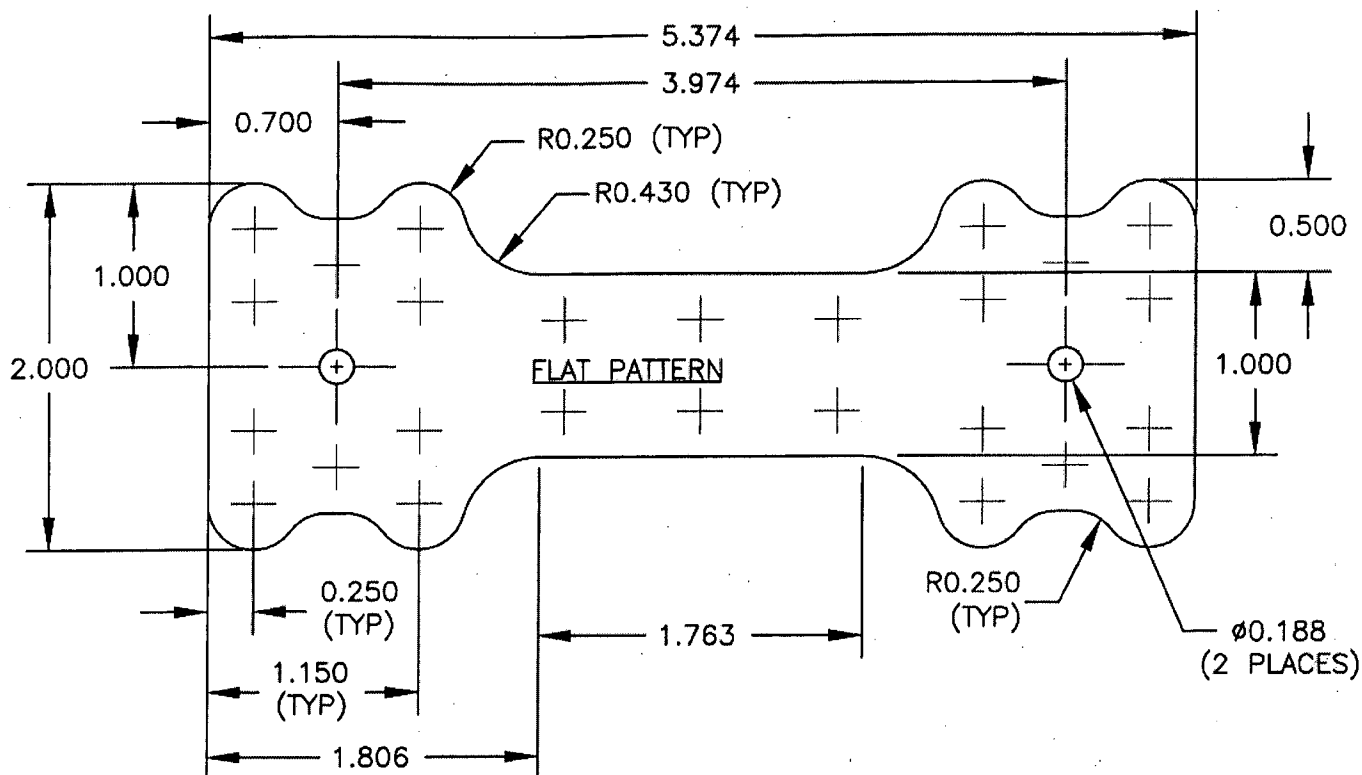
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

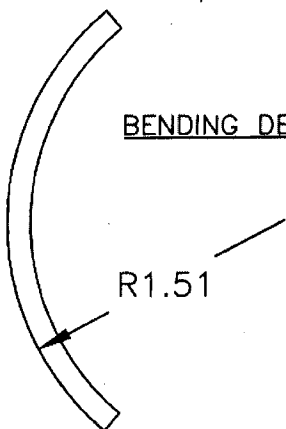


| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>UP</i> | DRAWN BY <i>UP</i> | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3286 | REV. A SHEET 1 OF 2 |
| DATE 04.05.06 | | TITLE GROUND HANDLING PARTS | SCALE 1:1 |
| A | 04.05.06 | NEW ISSUE | |



+ INDICATES LOCATION OF RIVET HOLES. SHOWN FOR REFERENCE ONLY, DO NOT DRILL.

BENDING DETAIL



RELEASED
04.06.22

D3286-1 DOUBLER

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK
(REF DART SPEC. M304S11GA)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

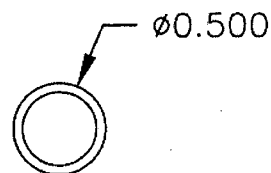
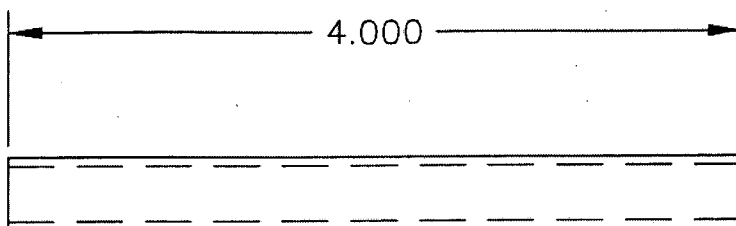
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WITHOUT NOTICE
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NO. 32514

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| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3286 | REV. A SHEET 2 OF 2 |
| DATE 04.05.06 | | TITLE GROUND HANDLING PARTS | SCALE 1:1 |



D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL
(REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
04.06.22 *[Signature]*

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